Work Orde February-21-13				*977	721*						Page 1
Item ID: Revision ID:	D3912-5			Accept	*N900	ი4010) 0*	Setup	Start	*N:	S1*
Item Name:	Eyebolt Plate								Stop	*N	S2*
Start Date:	3/04/13	Start Qty: 12.00	*12) *	Cust Item I	D:					
Required Date:	3/04/13	Req'd Qty: 12.00	*12) *	Customer:						
Reference:			:					D			
Approvals:	Process Pla	an:	Date:	Tooling:	D:	ate:		Run	Start	*N	R1*
				SPC (Y/N):	D:	ate:			Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Pla Co	-	ot Re Qt		Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr							•		
D3912	В					· ·					
100				0.00							
100 Waterjet		Memo		0.00			/8	<u> </u>	Δ		Jm 13-3-18
FLOW CNC Waterj	et	Cut as per of Prog Rev:_ Dwg Rev:_	B								
		Deburr as r	equired								
110		QC2- Inspect parts off r	nachine FAI/FAIB	0.00							
110 QC		Memo	•	0.00			18		0		JM3-3-1

Quality Control

NCR:	Yes	1	No
NCR.	162	/	INO

DQA: ____ Date: __

NCR: Y	es	/ No				WORK ORDER NON-	CON	IFUKI	MANCE / UP	DATE	QA Closed:	Date:	
Morte Ondo						DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
Nork Orde Part N	-					Rework Scrap	- - -		Skid-tube Machining	Crosstube Small Fab	Prod	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	o					Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root					Descri	ption of work order update	1	nitial		tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator Material etup Other													
upplier													
raining	-						ŀ						
Inapproved	1			<u> </u>		F	AUL	T CATE	GORY			<u> </u>	
Landir	ng G	iear				General							
		Bending Centre No Cracks Crushed/O			o/s	Bend BOM/Route Broken/Damaged Burrs		•	re on Incomplete ions Incomplete/	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi	ct _	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
ŀ	_	Cuffs	cimpeu,			Contamination		Mainte	· ·		Part Moved		
ţ	\dashv	Heat Trea	t			Countersink		Mislabe	led		Positioned V	Vrong	
		Inspection	n Strip in	Tube		Cut Too Short		Misreac	ł		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes	\vdash	Offset					
		Torque W	aves in E	xtrusio	n	Drawing	\vdash		Calibration				
		Turning Se	equence			Finish		Out of S	Sequence				
		Wave/Tw	ist in Tub	oe .		Folio		Outside	Dimensions				

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Work Orde February-21-13				*977	21*						Page 2
Item ID: Revision ID: Item Name: Start Date: Required Date:	D3912-5 Eyebolt Plate 3/04/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		*N900 Cust Item I Customer:		100)*	Setup St	ıv	S1* S2*
Reference: Approvals:		nn:		-		ate:		1		art *N	R1* R2*
Sequence ID/ Work Center I 120 *120* QC Quality Control	D	Operation Description QC8- Inspect parts - seco	and check	Set Up/ Run Hours 0.00 Smb	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*130 *130* Packaging Packaging		Identify as per dwg & St Memo	ock Location: <u>\$1</u> /	99 0.00 0.00				-18x			13-3-13
140 *1 4 1 4 1 * QC Quality Control		QC21- Final Inspection Memo	- Work Order Release	0.00					_ :	13/3	3/14 8
										NB	319

												DQA:	Date	e: _	
NCR:	⁄es	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPI	DATE				_	
												QA Closed:	Date	e:_	
Work Orde						DISPOSITION				AGAINST D)EF	PARTMENT	PROCESS		
Work Orde	-					Rework	1		Skid-tube	Crosstube	٦		Water Jet	\neg	Engineering
Part N	No.					Scrap	1		Machining	Small Fab	┪	Pro	d. Eng. Coor.	ᅱ	Quality
	_					Use-as-is	1		noforming	Finishing	٦		e/Packaging	٦	Other
NCR N	۱o					Work Order Update			Large Fab	Composite			Supplier		
							7				_				
Root	1					ption of work order update	1	Initial		tion		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Cr	nief Eng	Desci	ription	_	Date	Verification	4	QC Inspector
Doc/Data	Ц						1				1				
Equip/Tooling	Ш														
Operator							Ì								
Material														ł	
Setup														١	
Other															
Process															
Supplier											ı			-	
Training															
Unapproved															
						F	AUI	T CATE	GORY						
Landi	ng G	ear				General	_	_				-			
		Bending				Bend		Grain				Ovalized	1		Pressure/Forced
1		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re	[_		Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorre	ct [Weld
	П	Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/	Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
}	П	Cuffs				Contamination		Mainte	enance			Part Moved			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

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Picklist Print

February-21-13 12:41:39 PM

Work Order ID:

97721

Parent Item:

D3912-5

Parent Item Name:

Eyebolt Plate

Start Date: 3/04/13

Required Date: 3/04/13

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP RevA: new issue DD 09.11.17 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	266.5500	0.05125	-0.647368 8			
304/316 0.125 Sheet										1.0	=		<u>Jm13</u> -3-
				·		1 0							

NCR:	Yes	/ No				WORK ORDER NON-	100	NFOR	MANCE / UPDATI	E			
											QA Closed:	Date:	
Work Ord	er:					DISPOSITION			A	GAINST DE	PARTMENT	PROCESS	
Part NCR	No.					Rework Scrap Use-as-is Work Order Update		Thern	Machining Sn noforming F	osstube mall Fab inishing mposite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root						ption of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Description	n	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												·	
							AUI	T CATE	GORY				
Land		1			_	General	_	1			l		7
	<u> </u>	Bending			.	Bend	<u> </u>	Grain		├ ─	Ovalized		Pressure/Forced
	<u>_</u>	Centre N	ot Conce	ntric to (o/s	BOM/Route	<u> </u>	Hardwa		-	Over/Under	 	Temperature/Cure
	\vdash	Cracks			<u> </u>	Broken/Damaged		1 '	on Incomplete	-	Part Incorre	⊢	Weld
	1	Crushed/	Crimped.		1	Burrs		Instruct	ions Incomplete/Unclea	ar [Part Lost/M	issing	Wrong Stock Pulled

Maintenance

Out of Calibration
Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio DQA:

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Date:

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

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DART AEROSPACE LTD	Work Order: 977	21
Description: Eyebolt Plate	Part Number: D391	2-5
Inspection Dwg: D3912 Rev: B	Page 1	of 1

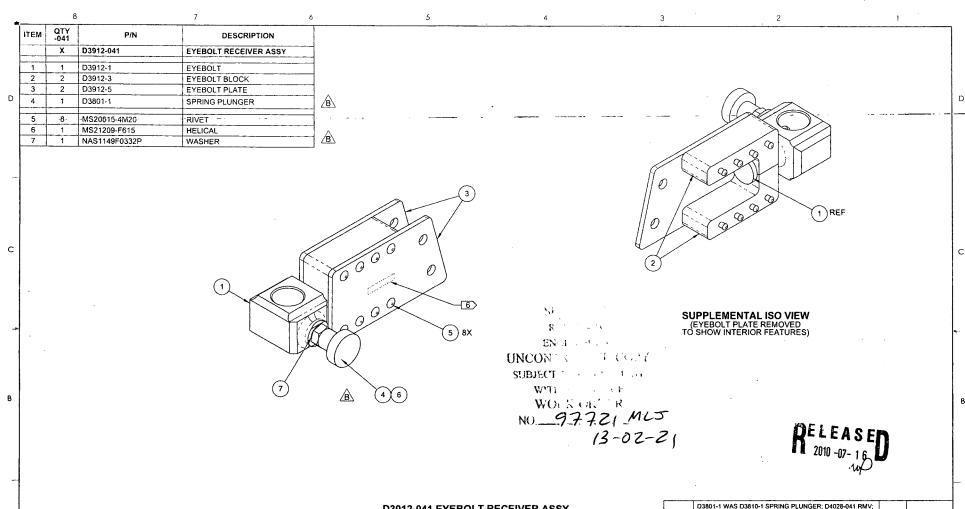
FIRST ARTICLE INSPECTION CHECKLIST

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension		Dimension			Inspection	
Ø0.129	+0.005/-0.001	0.131"	-		V	JAmoi
Ø0.257	+0.006-0.001	0.928,	-		V	
0.38	+/-0.030	o.382°	_		ν	
1.500	+/-0.010	1.506	_		✓	
0.500 Pitch	+/-0.010	0.505"	_		v	
3.15	+/-0.030	3.15"	_		υ	
0.375	+/-0.010	0.382"	-		V	
0.517	+/-0.010	0,519	~		V	
1.000	+/-0.010	0.999	_		V	
3.65	+/-0.030	3654	_		V	
1.500	+0.020/-0.000	1.5005	-		V	
0.25	+/-0.030	0.258"	_		, V	
2.00	+/-0.030	2.012"	-		ν	
0.125	+/-0.010	0.117"	_		V	

						, , , , , , , , , , , , , , , , , , ,
				-		
					-	

Measured by: \mathcal{J}_{m}	Audited by:	SMB	Preliminary Approval:	
Date: (3-3-12	Date:	15-3.12	Date:	

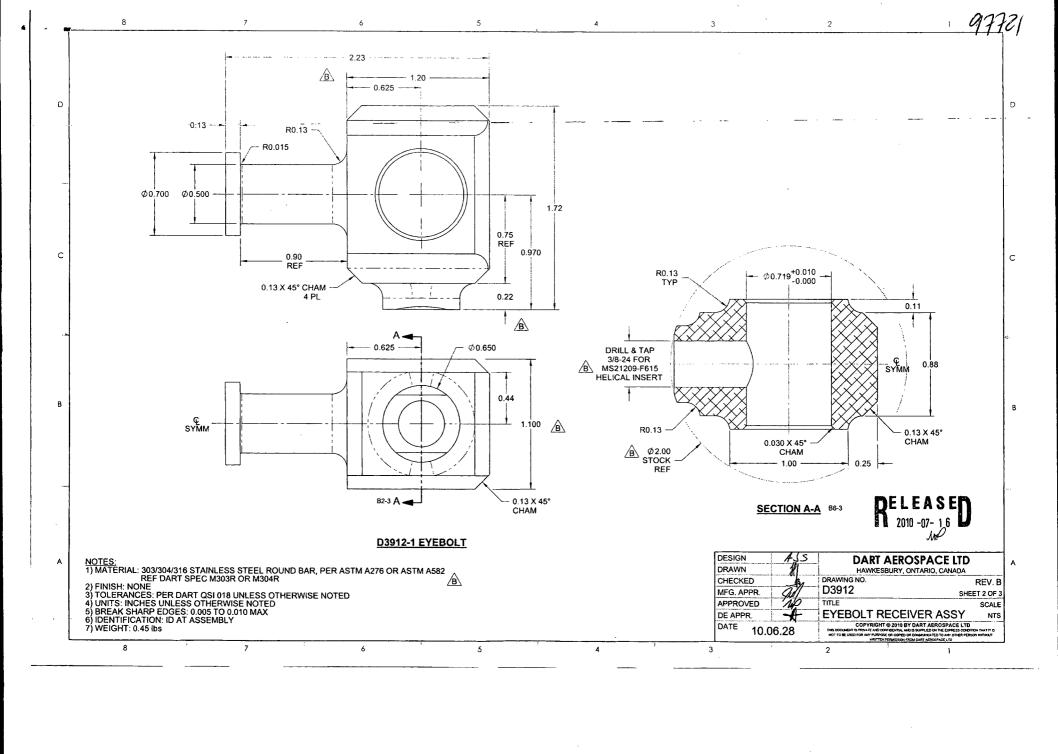
Rev	Date	Change	Revis	sed b	у	Approved
Α	10.06.07	New Issue	KJ	1_		1.1
В	10.08.09	Dwg Rev updated	KJ	- OK	7	144
					7	



D3912-041 EYEBOLT RECEIVER ASSY

В	D3801-1 MS2120 NAS114	WAS D3810- 9-F615 WAS 9C0663R ADI	1 SPRING PLUNGER; D4028-041 RMV; MS21209-C610 HELICAL; (1) WASHER DED; BOSS ADDED TO D3912-1.	JPH	10.06.28			
A	NEW IS	SUE		JPH	10.03.04			
REV.			DESCRIPTION	BY	DATE			
DESIG		455	DART AEROSPA HAWKESBURY, ONTAR		_			
CHECK	ED		DRAWING NO. D3912	angle of the contract of the c	REV. B			
APPRO	VED	119	TITLE EYEBOLT RECEIVER		SCALE			
DE API		6.28	TEXT ENGINE OF STREET OF S					

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER



D

0.800+0.000 2.30 Ø0.129 THRU 1.500 4 PL 0.400 0.500 PITCH 0.50 REF 1.00 0.750 +0.000 R0.13 0.500 R0.125 0.516 +0.015 -0.000 0.63

D3912-3 EYEBOLT BLOCK

3.15 1.500 0.500 PITCH 10.375 R0.13 TYP 0.38 0.25 0.517 1.000 1.500 +0.020 2.00 REF Ø0.129 Ø0.257 8 PL 0.125 2 PL REF 3.65 REF

D3912-5 EYEBOLT PLATE

	_		
DESIGN	455	DART AEROSPACE LTD	
DRAWN	181	HAWKESBURY, ONTARIO, CANADA	
CHECKED	-An	DRAWING NO.	REV. B
MFG. APPR.	GH/	D3912	SHEET 3 OF 3
APPROVED	149	TITLE	SCALE

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MOT TO BE USED FOR ANY PAPPOSE OR COPED OR COMMANDATE TO NAV OTHER PERSON WITHOUT
WORTHOM-PURPOSES ON PROMISED ANY PAPPOSE OR OTHER PERSON WITHOUT DATE 10.06.28

NOTES: 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M303B OR M304B

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240 REF DART SPEC M303S11GA OR M304S11GA

D

C

В

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ID AT ASSEMBLY
7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

8